

**\*124163\***

Page 1

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 9/10/14      **Start Qty:** 24.00

**\*24\***

**Cust Item ID:**

**Required Date:** 9/10/14      **Req'd Qty:** 24.00

**\*24\***

**Customer:**

**Reference:**

**Date:** 14-09-12 **Tooling:**

**Date:**

Run Start \*NR1\*

QC: \_\_\_\_\_

**Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_

Date:

Stop \*NR2\*

Draw Nbr	Revision Nbr
D2372	B

0.00

## PURCHASING

## Memo

Issue P/O: 25765  
Possible Supplier: Reid Tools  
Supplier part#: KCL-208  
C O F C is required

0.00

CL 14/09/15 24

Receive & Inspect for Damage & Mat'l Certs

0.00

## Memo

0.00

## Packaging

5/4/18 (24)

QC6- Inspect dimensions to drawing

0.00

## Memo

0.00

## Quality Control

**DAS**

38

9-89

14-9-25

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>             Skid-tube <input type="checkbox"/>              Machining <input type="checkbox"/>              Thermoforming <input type="checkbox"/>              Large Fab <input type="checkbox"/> </div> <div>             Crosstube <input type="checkbox"/>              Small Fab <input type="checkbox"/>              Finishing <input type="checkbox"/>              Composite <input type="checkbox"/> </div> <div>             Water Jet <input type="checkbox"/>              Prod. Eng. Coord. <input type="checkbox"/>              Rec/Store/Packaging <input type="checkbox"/>              Supplier <input type="checkbox"/> </div> <div>             Engineering <input type="checkbox"/>              Quality <input type="checkbox"/>              Other <input type="checkbox"/> </div> </div>
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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**Work Order ID 124163**

September-11-14 11:56:58 AM

**\*124163\***

Page 2

Item ID: D2372-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Cam Lever

Start Date: 9/10/14 Start Qty: 24.00

**\*24\***

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 24.00

**\*24\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>GA</i>	0.00							
<b>*130*</b>									
Packaging	Memo	0.00							DAS 26 9-89
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

*ML5* *14-09-29**MF*  
*14-9-26*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other
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# Picklist Print

September-11-14 11:56:58 AM

Page 1

Work Order ID: 124163

**\*124163\***

Parent Item: D2372-1

**\*D2372-1\***

Parent Item Name: Cam Lever

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP REV:A 12.02.07 new issue DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
KCL-208		Purchased	No			110	Each	0.0000	1	24			

**\*KCL-208\***

Cam Lever

**\*\***

*9/9/14* *(29)*

DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. _____  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>
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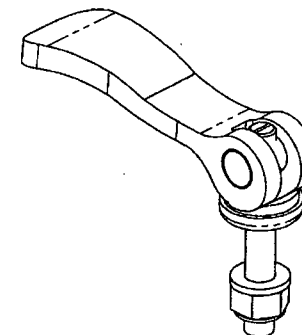
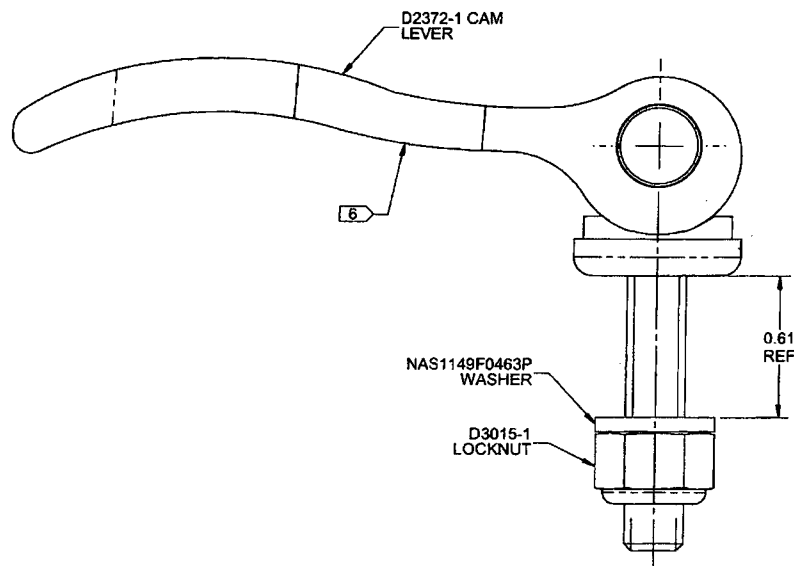
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

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ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D2372	QUICK RELEASE
1	1	D2372-1	CAM LEVER
2	1	D3015-1	LOCKNUT
3	1	NAS1149F0463P	WASHER

## SPECIFICATION CONTROL DRAWING



NOT A COPY  
 RETURN TO  
 ENGINEERING  
 ACTION CONTROLLED COPY  
 APPROVED FOR AMENDMENT  
 WORK ORDER

124163 MLJ  
 14-09-12

**RELEASED**  
 2012-02-06  
 JW

### D2372 QUICK RELEASE

#### NOTES:

- 1) MATERIAL: SEE SHEET 2
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2372" AND B/N "BXXXXX" PER DART QSI 044 6.5 (LABEL)
- 7) WEIGHT: 0.11 lbs

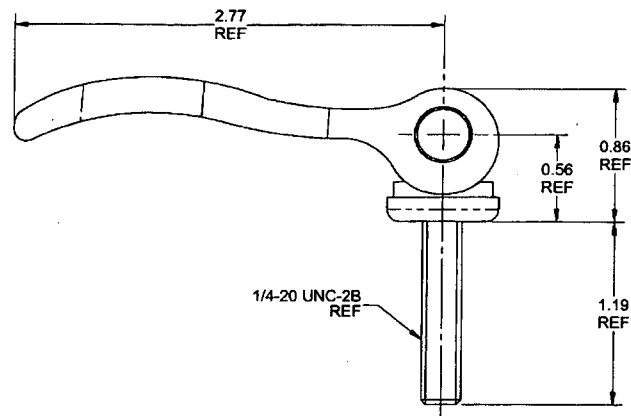
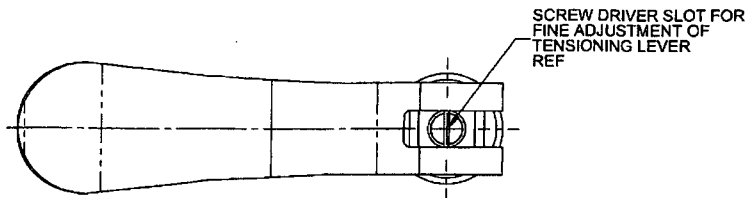
B	RE-DRAWN IAW QSI 043/044; SUPPLIER AND SUPPLIER P/N WERE "NORCO" AND "25-5128-01". REF: PART 12-159.	MB	12.01.31
A	NEW ISSUE	BW	95.02.24
REV.	DESCRIPTION	BY	DATE
DESIGN	BW		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.01.31		

**DART AEROSPACE LTD**  
 HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. B  
**D2372**  
 SHEET 1 OF 2  
 TITLE SCALE  
**QUICK RELEASE** NTS

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# SPECIFICATION CONTROL DRAWING



**D2372-1 CAM LEVER**

DART PART NUMBER	DESCRIPTION	SUPPLIER	SUPPLIER PART NUMBER	MATERIAL	WEIGHT
D2372-1	CAM LEVER	REID TOOLS (PREFERRED)	KCL-208	HANDLE: ALUMINUM	0.10 lbs
		McMASTER-CARR (ALTERNATE)	5720K52	CAM WASHER: NYLON THREADED STUD, PIN, CAP WASHER: STAINLESS STEEL	

- NOTES:
- 1) MATERIAL: SEE TABLE
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: SEE TABLE

DESIGN	BW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED	GP	DRAWING NO.	REV. B
MFG. APPR.	EG	D2372	SHEET 2 OF 2
APPROVED	1/18	TITLE	SCALE
DE APPR.		QUICK RELEASE	NTS
DATE	12.01.31	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED  
2012-02-06





Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO25765**

Purchase Order Date 9/15/2014

PO Print Date 9/15/2014

Page Number 1 of 2

**Order From :**

VU-REI001

**Ship To :** DART AEROSPACE LTD

ESSENTRA COMPONENTS  
62919 COLLECTION CENTRE DRIVE  
CHICAGO, IL 60693-0629  
US

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA



**Contact Name**

**Vendor Phone**

800 253 0421

**Buyer**

Chantal Lavoie

**Customer POID**

**Customer Tax #**

10127-2607

**Ship To Contact**

**Ship To Phone**

**Ship Via:**

FedEx Overnight collect

**Ship Acct:**

**Terms**

Net 30

**Currency**

USD

**FOB**

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments		Promise Date					
Delivery Comments							
1	KCL-208	Cam Lever	9/18/2014		24.00	\$22.67	\$544.08
			Yes		Each		
			9/18/2014				
AS PER DWG D2372 REV. B B124163							
						Line Total:	\$544.08
2	BLRS-002	Quick Release Pin (3/16" x 1.5")	9/18/2014		12.00	\$24.56	\$294.72
			Yes		Each		
			9/18/2014				
						Line Total:	\$294.72

**Note:**

9/15/2014



**ESSENTRA**

COMPONENTS

2200 Black Creek Road  
Muskegon, MI 49444-2684  
Phone: 231-777-3951  
Fax: 800-438-1145  
www.essentracomponents.com

DELIVERY NOTE:



P02998101527251

CUSTOMER PO#



P025765

**Bill To:** DART AEROSPACE  
1270 ABERDEEN ST  
HAWKESBURY, ON K6A 1K7  
CANADA

**Ship To:**

DART AEROSPACE  
1270 ABERDEEN ST  
HAWKESBURY, ON K6A 1K7  
CANADA



**APPROVED**

CUSTOMER NO		ORDER #		SHIPPED VIA		SHIP DATE	
45215650		1527251		FXIE / FedEx Int'l Economy		09/16/14	
ORD LN	Item	Description		Order Quantity	Pick Quantity	UNIT	
✓	KCL-208	2.77 SS ADJ CAM LEVER 1/4-20 X		.024	.024	TH	
2	BLRS-002A	3/16 X 1-1/2 SS BL PIN		.012	.012	TH	

This is to certify that the above material shipped against your purchase order is in conformance with all known requirements, specifications and drawings in effect at the time of manufacture. All applicable physical, functional, dimensional and material test reports are on file at our facility, and may be inspected by your representative upon request.

**Cathy Reid**  
DOCUMENT CONTROL SUPERVISOR